

# Work Order ID 86604

**\*86604\***

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Thursday, July 05, 2012 3:26:10 PM

Item ID: D3608-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Lower Doubler

Stop **\*NS2\***

Start Date: 7/5/2012 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 7/12/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference: REWORK TO POLISH

Approvals: Process Plan: *mf*

Date: 12-07-05

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3608

C

170

0.00

**\*170\***

QC

Memo

0.00

Quality Control

PULL FROM STOCK D3608-1 X 6 B78850

*CX 12/07/17*

180

Outsource process - Electrochemically polish

0.00

**\*180\***

Outsource6

Memo

0.00

Outsource process - Electrochemical

SEND TO TQF FOR ELECTROPOLISHING

*P/O 17481  
CP Tech*

*CX 12/07/17 8*

190

Receive & Inspect for Damage & Mat'l Certs

0.00

**\*190\***

Packaging

Memo

0.00

Packaging

*CX 12/11/27 (8)*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 86604

\*86604\*

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Required Date: 7/12/2012 Req'd Qty: 6.00

\*6\*

Customer:

Reference: REWORK TO POLISH

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

200

QC5- Inspect part completeness to step on W/O

0.00

\*200\*

QC

Memo

0.00

Quality Control

DAS  
16  
9-83 12/4/13

(28)

210

Identify as per dwg & Stock Location: 175

0.00

\*210\*

Packaging

Memo

0.00

Packaging

812

12/3/27

220

QC21- Final Inspection - Work Order Release

0.00

\*220\*

QC

Memo

0.00

Quality Control

12/7/30

mf  
12-07-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, July 05, 2012 3:26:10 PM

Page 1

Work Order ID: 86604  
 Parent Item: D3608-1  
 Parent Item Name: Lower Doubler

Start Date: 7/5/2012

Required Date: 7/12/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-03-26 JLM  
 IPP Rev:B 08-10-15 preliminary issue DD verified by:EC  
 IPP Rev:C 08-12-11 rev.A as per dwg DD verified by:EC IPP Rev:D 10.02.16 rev.B as  
 per dwg DD verified by:EC IPP Rev:E 10.11.17 as per PC1 dwg DD verified by:EC IPP  
 Rev:F 10.11.29 as per revC dwg DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3608-1 Lower Doubler		Manufactured	No				Each	0.0000		6		6/21/12	⑧

6 x 78850

MF  
12-07-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO17481

Purchase Order Date 7/18/12

PO Print Date 7/19/12

Page Number 1 of 1

Order From : VC-WEM001  
WATERLOO ELECTROPLATING & METAL FINISHING INC.  
105 RANDALL DRIVE  
WATERLOO, ONTARIO N2V 1C5  
CANADA

Contact Name

Vendor Phone

519-884-0797

Vendor Fax

519-884-4937

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	86605	D3608-3 UPPER DOUBLER	7/27/12 Yes	7.00	FedEx PI collect	\$30.0000	\$210.00
		Special Inst: ELECTROPOLISH AS PER BAPS 160-036					
	86604	D3608-1 LOWER DOUBLER	7/27/12 Yes	8.00	FedEx PI collect	\$30.0000	\$240.00
		Special Inst: ELECTROPOLISH AS PER BAPS 160-036					
3	86607	D3609-1 FUEL PANEL	7/27/12 Yes	3.00	FedEx PI collect	\$25.0000	\$75.00
		Special Inst: ELECTROPOLISH AS PER BAPS 160-036					
PO Total:							\$525.00

Change Nbr: 3

Change Date: 7/19/12

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required - YES NO

# Waterloo Electroplating & Metal Finishing Inc.

*We bring excellence to the surface*

## CERTIFICATE OF COMPLIANCE

**Issued to:** Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7

**Date:** July 26, 2012  
**P.O. #** PO17481

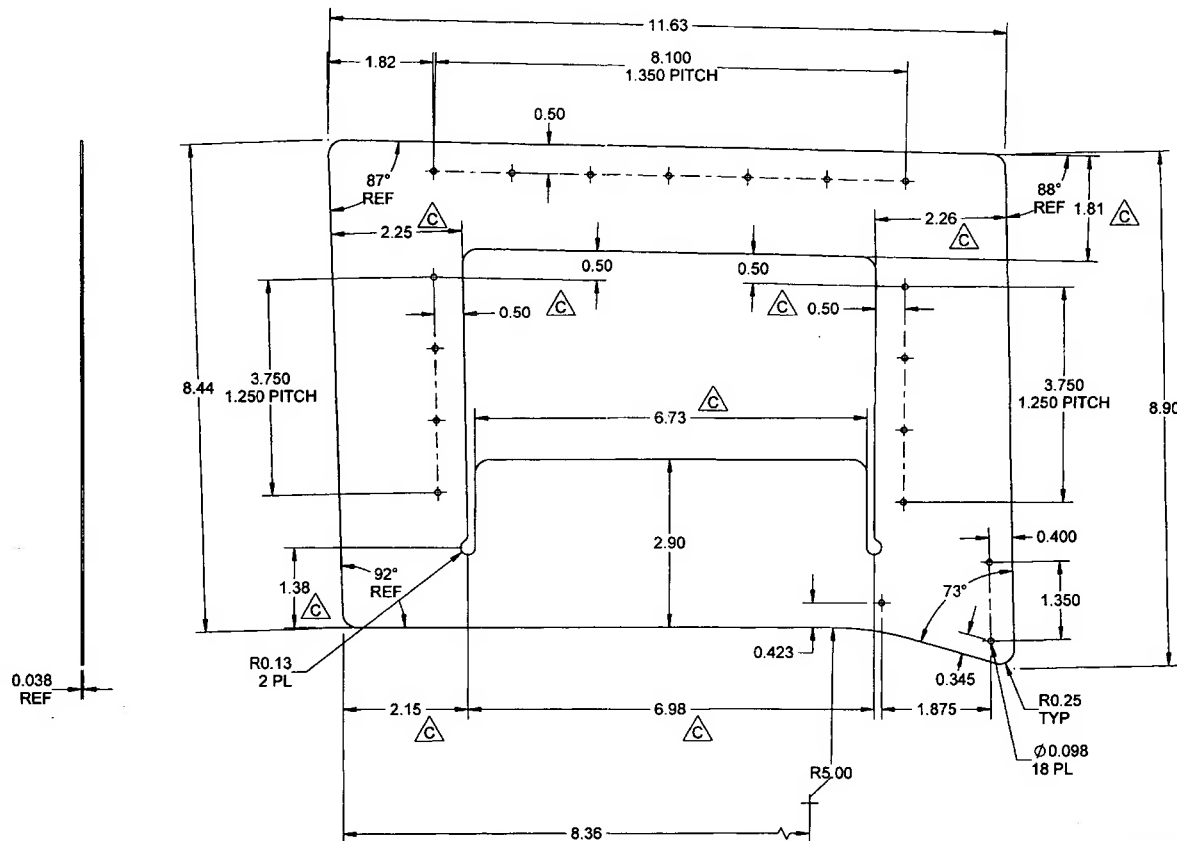
This is to certify that the items listed below have been processed and finished in compliance to the specifications in the contract or purchase order.

Part #	Description	Qty	Specification
86605	D3608-3 Upper Doubler	7	Electropolish BAPS 160-036
86604	D3608-1 Lower Doubler	8	Electropolish BAPS 160-036
86607	D3609-1 Fuel Panel	3	Electropolish BAPS 160-036

For and on behalf of  
WATERLOO ELECTROPLATING  
Q. C.

*Shakil Ahsan*





RELEASED  
2010-11-23

# **D3608-1 LOWER DOUBLER**

## **NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 20 GAUGE  
PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316)  
OR ASTM A240 OR ASTM SA240  
REF DART SPEC M304S20GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 C
- 7) WEIGHT: 0.76 lbs

C	OFFSET TOP AND VERTICAL EDGES OF RECTANGULAR OPENING BY 0.250 OUTWARDS; UPDATE IDENTIFICATION REFERENCE	MB	10.11.19
B	OFFSET TOP AND VERTICAL EDGES OF RECTANGULAR OPENING BY 0.250 INWARDS; ELIMINATE D3608-1F/3F; DELETED BENDING DETAILS. REASON: D3608-1/3 NOW SOLD TO CUSTOMERS UNBENT PER PAR909-097	MB	10.02.05
A	NEW ISSUE	MB	07.04.11
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D3608</b> TITLE <b>DOUBLER</b> COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>	REV. C SHEET 1 OF 2 SCALE NTS	
DATE	10.11.19		